

A nip pressure of about 264 pound per linear inch produces satisfactory results for the preferred web described above, having three layers and a total basis weight of 64 grams per square meter (gsm).

5 The layered, bonded, and calendared web can then be wound as roll stock on a parent roll 50 for storage or further processing.

10 While particular embodiments and/or individual features of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. Further, it should be apparent that all combinations of such embodiments and features are possible and can result in preferred executions of the invention. Therefore, the appended claims are intended to cover all such changes and modifications that are within the scope of this invention.

15 WHAT IS CLAIMED IS:

1. A multi-layer nonwoven web suitable for use as a wet wipe, the web comprising:
 - (a) a first fibrous outer layer comprising from about 10% to about 60% conjugate fiber, from about 20% to about 65% cellulosic fibers;
 - (b) a fibrous inner layer comprising from about 10% to about 60% conjugate fiber, from about 10% to about 90% cellulosic fibers, said inner layer bonded at discrete bond sites to said first outer layer in a face to face relationship; and
 - (c) A second fibrous outer layer comprising from about 10% to about 60% conjugate fiber, from about 20% to about 65% cellulosic fibers, said second fibrous outer layer bonded at discrete bond sites to said inner layer in a face to face relationship.
2. The nonwoven web of Claim 1, wherein said first and second outer layer comprise identical fiber compositions.
3. The nonwoven web of Claim 1, wherein said first and second outer layers together comprise from about 20% to about 80% of the total basis weight of the web.
4. The nonwoven web of Claim 1, wherein said first and second outer layers each comprise from 20% to about 60% of the total basis weight of the web.
5. The nonwoven web of Claim 1, wherein said inner layer comprises from about 33% to about 80% of the total basis weight of the web.
6. The nonwoven web of Claim 1, wherein said web is formed in the absence of adhesive.
7. A method for forming a multi-layer nonwoven web suitable for use as a wet wipe, the method comprising the steps of:
 - (a) providing a carded web, a airlaid web and another carded web each said web having a predetermined amount of conjugate fibers;
 - (b) providing a thermal treatment apparatus;
 - (c) providing a calendar emboss apparatus;

- (d) positioning a carded web, a airlaid web and another carded web in a layered, face-to-face relationship;
- (e) transferring said layered carded web, airlaid web and carded web to said thermal treatment apparatus;
- (f) holding said layered carded web, airlaid web and carded web for sufficient dwell time to effect bonding between a plurality of said conjugate fibers to form a bonded unitary web;
- (g) transferring said unitary web to said calendar emboss apparatus; and
- (h) embossing said unitary web.

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